Work Orde				*103	372*						Page 1
Item ID: Revision ID:	D3914-041			Accept	*N900	040	100)* s	Setup Stai	rt *N	S1*
Item Name:	Long Basket i	Lid Assembiy (350)							Sto	" *N	S2*
Start Date:	6/24/2013	Start Qty: 1.00	*1*		Cust Item	ID:					
Required Date:	7/5/2013	Req'd Qty: 1.00	*1*		Customer:						
Reference:								_			
Approvals:	Process Pla	an:	Date; 13.00-2	✓ Tooling:	D	ate:		F	Run Stai	171	R1*
	QC:		Date:		D	ate:	,		Sto	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3914	С										
D4020	Α		212								
100			S. rod Batch: 124816	0.00				1.			
100		Large Fab		0.00				10.0			
Large Fab		Memo	1	0.00		\cap			\		
Large Fab			le ribs, weld as per dwg D		/	11,	_	10.0	·		
		2- weld hi	nge (3) and Mounting brac	kets as per dwg D3914		1.0	13	10			
		Visual	inspect before welding me	sh		YP					
		3- tack we	eld mesh on basket as per d	wg D3914		•					
			Make sure to place mesh c	pes in center off basket lid a correctly on lid, check with la		•					
110	٠	QC9- Inspect visual pe	r QSI004- Fusion Welds	0.00							Dago
110				0.00					_13	10.03	<u></u>
QC Quality Control		Memo		0.00							-3
Zumity Control											

	der ID 10	
Item ID:	D3914-041	10.10 11M
Revision ID:		
Item Name:	Long Basket	Lid Assembly (350)
Start Date:	6/24/2013	Start Qty: 1.00

Monday, June 2				*1()?	3372*							Page 2
Item ID: Revision ID: Item Name:	D3914-041	Lid Assembly (350)		Accept	*N900	040	100	n*	Setup	Start Stop	i Vi	S1* S2*
Start Date: Required Date: Reference:	6/24/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I	ID:		•			IV	.J/
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:	_	F	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
120		QC5- Inspect part comp	leteness to step on W/O	0.00								/ D4 a
120 QC Quality Control		Memo		0.00				To the second production of the second secon	,	5:10-	0 3	00
130 *130*		Black Sandtex(Ref:4.3.5	5.7) per QSI005 4.3	0.00				/ v	. V	(par	7-1-1	7/10/
Powdercoat		Memo	<i>(</i> 1.2)	0.00				l-X_	<i>9</i>	0///	///	3/10/0 ₀
Powder Coating	S	*** mask si Start Time:_ Oven Temp Finish Time	erature: SO	dercoat***				,		•		
140		Wing Walk as per dwg (QSI005 4.4 Batch <u>M / 2</u>	654a				1	_[iR i	0 0	. ln. e
140 HandFinish		Memo		0.00				/	<u> </u>	D	110	10.3.
Hand Finishing			ta plate and apply wing wa	alk on outside surface of m	nesh as per dwg				-			
		2- Install pla	acard and label as per dwg		15 1 24							

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

Work Order ID 103372

Quality Control

103372

Page 3

Monday, June 24, 2013 11:08:16 AM Item ID: D3914-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Long Basket Lid Assembly (350) **Start Date:** 6/24/2013 Start Qty: 1.00 **Cust Item ID:** Required Date: 7/5/2013 Req'd Qty: 1.00 **Customer:** Reference: Run Start Tooling: Approvals: Process Plan: Date: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Set Up/ Tool # Plan Reject Operation Tool ID Accept Reject Insp. Work Center ID Qty **Description Run Hours** Code **Qty** Number Stamp 150 QC3-Inspect Part Finish 0.00 *150* 0.00 Memo Quality Control 108506 Identify as per dwg & Stock Location D40 30 060 160 1 \$ BL13-10-3. *160* Packaging 0.00 Memo Packaging 1 12-10-1 QC21- Final Inspection - Work Order Release 170 0.00 QC 0.00 Memo

Monday, June 24, 2013 11:08:21 AM

Work Order ID: 103372

103372

Parent Item:

D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/24/2013

Required Date: 7/5/2013

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B

as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:C 13.03.14 AS

PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG

82131 87079 97660

No

Manufactured

RI	EV.C DD VER	F:JFS											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
^{D3914-1} * □3914-1*		Manufactured	No			100	Each	12.0000	2 **	2	Cpl	13.10	.01
Rib				<u>Location</u>		Loc (<u>Oty</u>	Loc Code		•	3103	3 6 7-	
		4		· WA004			8				_		
					100751		6						
			١.	•	88645		2				<u>. </u>		
,		••		WA005			4	•			_		
					81449		1		·		_		

100

D3914-7

**

13.0000

Location	Loc Oty	Loc Code	
WA004	8		
100888	8		
WA005	5		
82928	3		
88649	1		
97949	1		

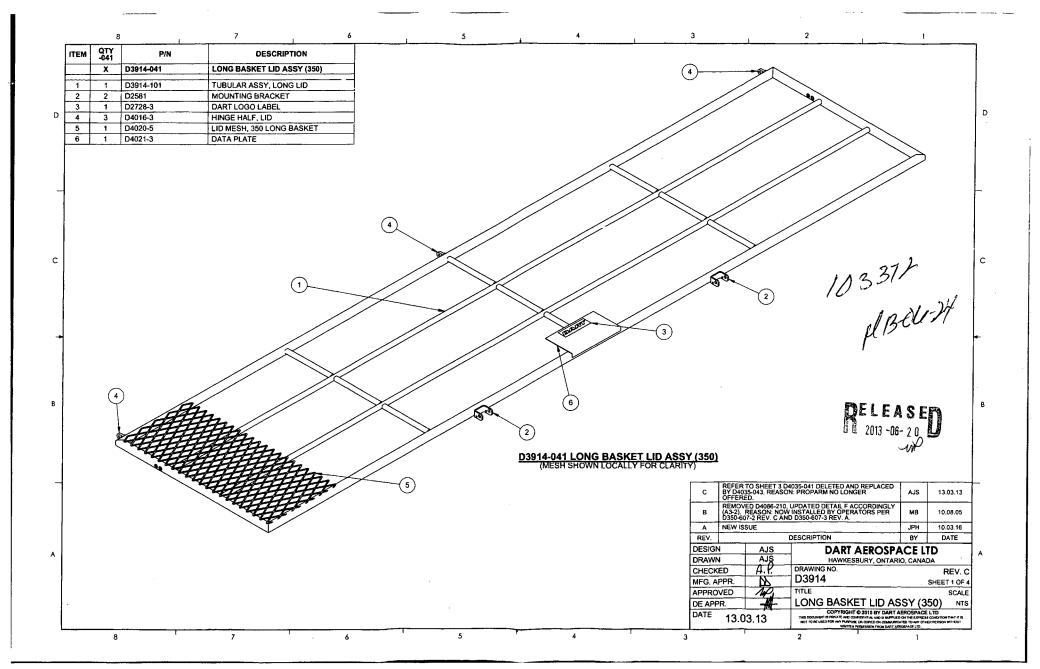
Each

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99837

Monday, June 24, 2013 11:08:21 AM

Work Order ID: 103372		*103372*						
Parent Item: D3914-041		*D3914-041*	•					
Parent Item Name: Long Basket	Lid Assembly (350)	17.13714-041			S	tart Date: 6	5/24/2013	Required Date: 7/5/2013
					5	Start Qty:	.00	Required Qty: 1.00
D2728-3	Manufactured	No	140	Each	0.0000	0	0	4 /
D2728-3 Dart Logo label large						**	_/_	A13-10-9
D4016-3	Manufactured	No	100	Each	38.0000	3	3	0
D4016-3 Hinge Half, Lid						**		CP(13.10.01
Hinge Hail, Liu		Location	<u>Lo</u>	c Qty	Loc Code			04365-
		WA004		38			_B1	010432
		101043		20				_
		102214 94755		8				
		94733 95563		8 2				
D4020-5	Manufactured	No	100	Each	4.0000	1	1	_
D4020-5	TVI and Table 1		2			**		10(13.10.01
Mesh (350 Basket Long, Lid)								B100416->
		Location	<u>Lo</u>	c Oty	Loc Code			D100416->
		WA007		4				
		92695		3				,
		96611		1				
D4021-3	Manufactured	No	100	Each	62.0000	1	1	\wedge
D4021-3						**		Cpl 13.10.01 B101346-> (1
Data i fate		Location	<u>Lo</u>	e Oty	Loc Code		<	B101346->(1
•		WA004		62				
		101346		52				
		80897		9				<u> </u>
		82507		1				_

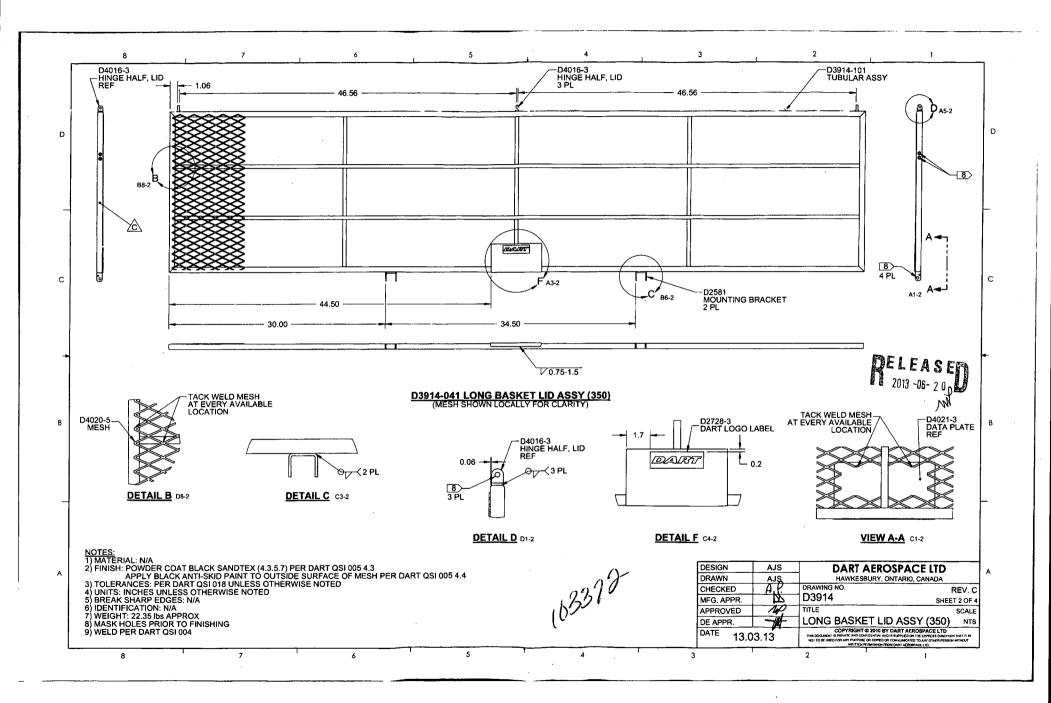


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Work Orde	ř:	<u> </u>			DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
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Ī	Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Vrong		-
ļ	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	'Surge	Other	
Ī	Ripples in				Drill Holes	П	Offset		_				
ļ	Torque W	/aves in 8	Extrusion	,	Drawing		Out of	Calibration					
, <u> </u>	Turning S				Finish		Out of S	Sequence					
	Wave/Tw	-			Folio		Outside	Dimensions					

DQA:

Date: ___

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												DQA:	Da	ite:	
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Work Ord	er.					Rework	1		Skid-tube	Crosstube	1		Water Jet		Engineering
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raiti	VO .					Use-as-is			noforming	Finishing			e/Packaging	-	Other
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		Bending				Bend	Г	Grain			lov	valized		Г	Pressure/Forced
	\vdash	Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		o,	/er/Under	tolerance	Г	Temperature/Cure
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		Heat Trea	at			Countersink		Mislabe	eled		Po	sitioned W	/rong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Po	wer Loss/S	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

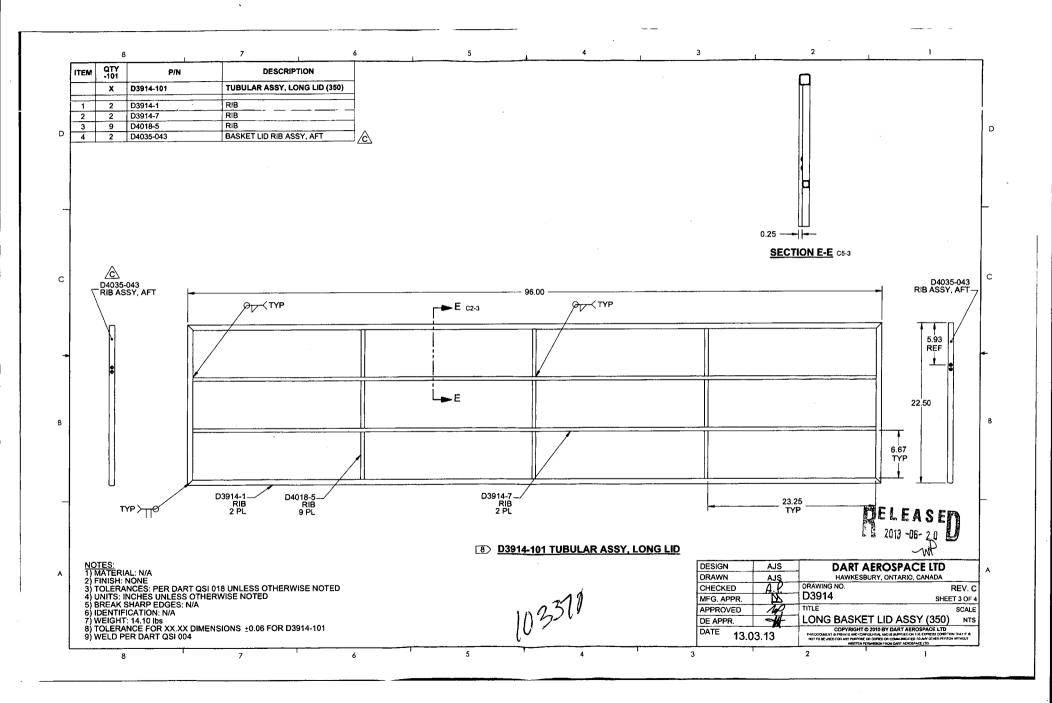
Cut Too Short Drill Holes

Drawing

Finish

Folio

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											DQA:	Date	:
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						<u> </u>					QA Closed.	Date	•
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
***********	-					Rework]		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is	1	Therm	noforming	Finishing		re/Packaging	Other
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Root						ption of work order update	1	Initial		tion	Sign &		·
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Landi	ng G	ear				General	,				· · · · · · · · · · · · · · · · · · ·		
		Bending				Bend		Grain			Ovalized	Г	Pressure/Forced
	\vdash	Centre No	ot Concer	ntric to	o/s 🗀	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	П	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
		Crushed/	Crimped			Burrs		Instructi	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		_
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ш	Ripples in	Bend			Drill Holes		Offset					
	1 1	Torque W	aves in E	xtrusio	n	Drawing		Out of C	alibration				

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

С 15.13 15.61 8 19.52 R3.0 TYP (9) <u>D4020-1 MESH (350 BASKET LONG, BASE)</u> (SEE D4020-1F FOR LENGTH) D4020-3 (350 BASKET SHORT, BASE) (SEE D4020-3F FOR LENGTH) NEW ISSUE 10.03.04 Α JPH NOTES:
1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED REV. DESCRIPTION BY DATE DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A 4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NA
6) IDENTIFICATION: NA
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY D4020 MFG. APPR. SHEET 1 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE) DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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												DQA:	Da	ate:	
NCR: Y	'es /	/ No				WORK ORDER NON-	100	NFORN	MANCE / UP	DATE	(QA Closed:	 Da	ate:	
						DISPOSITION				AGAINST DI					
Work Orde	er: _						,				7			_	1
Part N	lo					Rework Scrap Use-as-is		ľ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	$\frac{1}{1}$		Water Jet d. Eng. Coor e/Packaging	·	Engineering Quality Other
NCR N	lo					Work Order Update]		Large Fab	Composite]	·	Supplie		
Root					Descri	ption of work order update	Π	Initial	Act	tion	I	Sign &			
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	\bigsqcup^{c}	uffs				Contamination	Maintenance				-1	Part Moved			
	⊦ل∐	leat Trea	at Countersink Mislabeled					-1	Positioned W	_	_	· •			
	[]h	nspection	n Strip in	Tube		Cut Too Short		Misread				Power Loss/Surge			Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

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8 R1.44 15.50 2.00 0.38 5.64 75 R3.38 2 PL 20.18 REF 9 D4020-11 END MESH, BASKET NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F DESIGN AJS DART AEROSPACE LTD 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1 23 ibes JPH HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 TITLE APPROVED SCALE 7) WEIGHT: 1.22 lbs 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS 9) TOLERANCE ON XX.XX DIMENSIONS $\pm\,0.06$. 350 BASKET MESH (BASE) DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
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3

2

NCR:	Yes	1	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:

Date:

NCN.					WORK ORDER NOR				QA Closed:	Date	2:
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT		
Part N	o				Rework Scrap	- - The	Skid-tube Machining	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Use-as-is Work Order Update	- The	moforming Large Fab	Composite	, Rec/sto	Supplier	- Other
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
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quip/Tooling										·	
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	Bending			<u> </u>	Bend	Grain			Ovalized	<u> </u>	Pressure/Forced
,	Centre N	ot Conce	ntric to	^{0/s} -	BOM/Route	Hardv		-	Over/Under	<u> </u>	Temperature/Cure Weld
	Cracks	· /c :		_	Broken/Damaged	_	ction Incomplete	// la elece	Part Incorre	├	Wrong Stock Pulled
	Crushed/	Crimped		-	Burrs		ctions Incomplete,	/Unclear	Part Lost/M	issing _	wrong Stock Pulled
	Cuffs			-	Contamination	\vdash	tenance	-	Part Moved	.	
	Heat Tre		T 6 -	—	Countersink	Misla		-	Positioned V		Other
	Inspectio		rube	ļ	Cut Too Short	Misre		· L	Power Loss/	ouige	Other
	Ripples in			_ ⊹⊢	Drill Holes	Offset					-
1		Vaves in I		n -	Drawing	i	f Calibration				
	Waye/Ty	Sequence		-	Finish	\vdash	f Sequence	•			